

Work Order ID 48539

June 26, 2009 7:42:31 AM



Page 1

Item ID: D3255-2

Accept



Setup Start



Revision ID: B

Item Name: Panel

Stop



Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3255

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3255 1 Dwg Rev: B 1 Prog Rev: B 1 2-
Debur if necessary

B 9-6-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-6-30

4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

- 509/07/01 (24)

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Page 2

Item ID: D3255-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Panel

Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3255

0.00

0.00

SB 09/07/06

(4)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 09/07/06 (44)

(44)

(2)

150



Packaging

Packaging

Identify as per dwg & Stock Location: 184

Memo

0.00

0.00

9/7/06 (40) Sy

Work Order ID 48539

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Page 3

Item ID: D3255-2

Revision ID: B

Item Name: Panel

Start Date: 15/07/2009 Start Qty: 4.00

Required Date: 03/08/2009 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/07

u 09-07-07

Picklist Print

June 26, 2009 7:42:31 AM

Page 1

Work Order ID: 48539

Parent Item: D3255-2RevB

Parent Item Name: Panel



Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ M304S22GA  304/316 .032 Sheet		Purchased	No			100	sf	0.0000	6.2484			
		m 109057			HB 9-6-30							

Date: Friday, 12/06/2009 9:55:08 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL
Job Number : 48539	
Estimate Number : 12501	
P.O. Number :	Part Number : D32552
This Issue : 12/06/2009 S.O. No. :	Drawing Number : D3255 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 47849	Material :
Written By :	Due Date : 19/06/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 09.06.12</u>	
Comment : Est Rev:A New Issue 06-08-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S22GA	304/316 .032 Sheet
-----	-----------	--------------------



Comment: Qty.: 1.5582 sf(s)/Unit Total : 6.2328 sf(s)
304/316 .032 Sheet
(M304S032)
Batch: 109057 1B 9-6-30

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3255
Dwg Rev: B
Prog Rev: B 1B 9-6-30
2-Deburr if necessary 1B 9-6-30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



1B 9-6-30



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
Form as per Dwg D3255

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:55:08 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL

Job Number: 48539

Part Number: D32552

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	48539
Description: Access Panel Assembly		Part Number:	D3255-2
Inspection Dwg: D3255	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

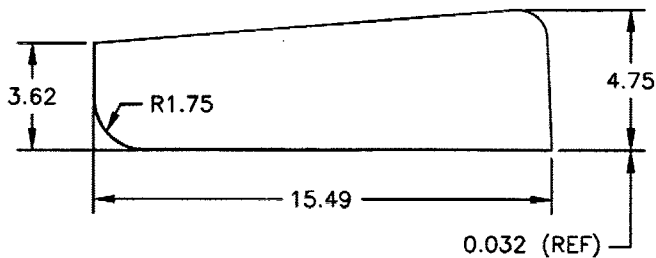
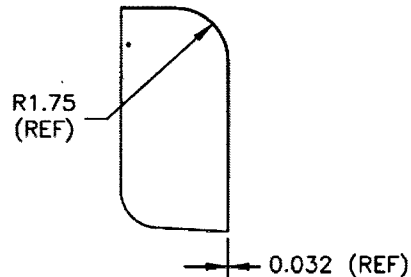
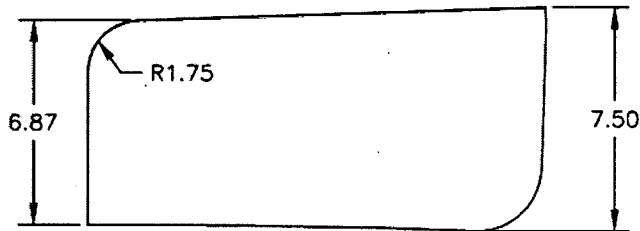
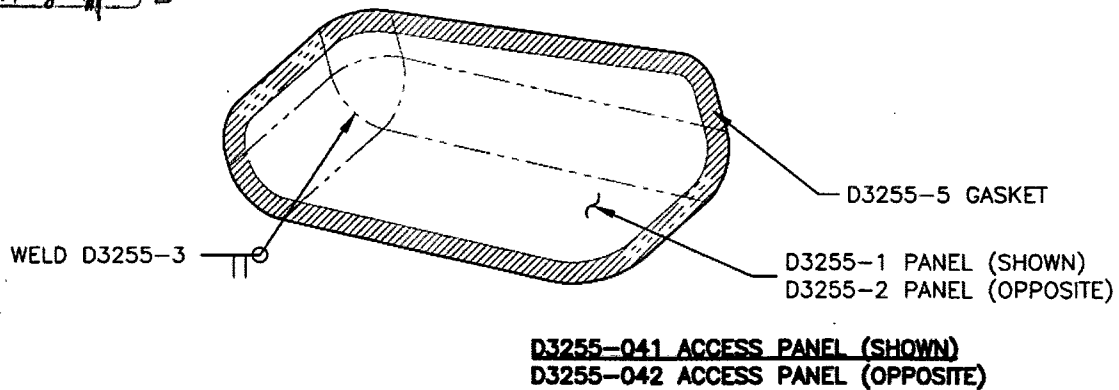
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	X			
15.171	+/-0.010	15.111	X			
10.032	+/-0.010	10.032	X			
6.902	+/-0.010	6.900	X			
18.456	+/-0.010	18.456	X			
11.432	+/-0.010	11.432	X			
2.261	+/-0.010	2.255	X			
2.363	+/-0.010	2.359	X			
2.363	+/-0.010	2.360	X			
1.183	+/-0.010	1.181	X			
0.250	+/-0.010	.248	X			
0.250	+/-0.010	.248	X			
2.261	+/-0.010	2.259	X			

Measured by: RB	Audited by: J	Prototype Approval:	N/A
Date: 9-6-30	Date: 09/07/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.06	New Issue	KJ/DD	

DART

DESIGN R#	DRAWN BY R#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-19 #

D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

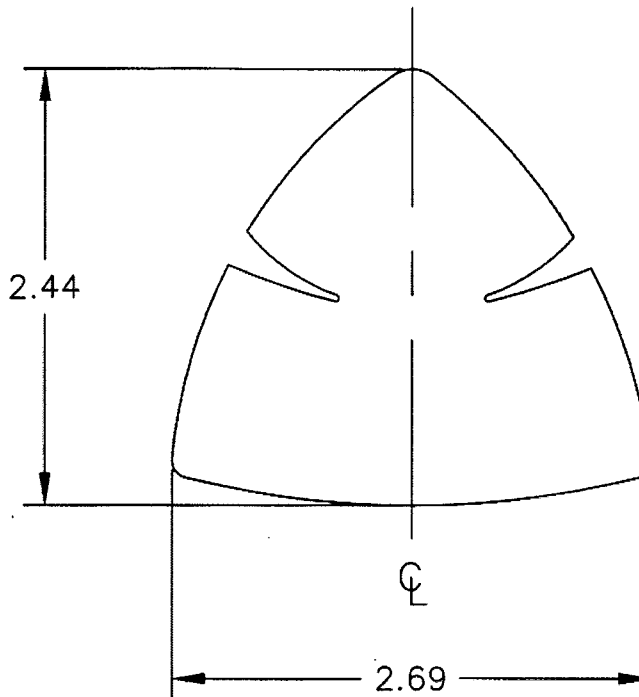
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DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4/	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.18 [Signature]

D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

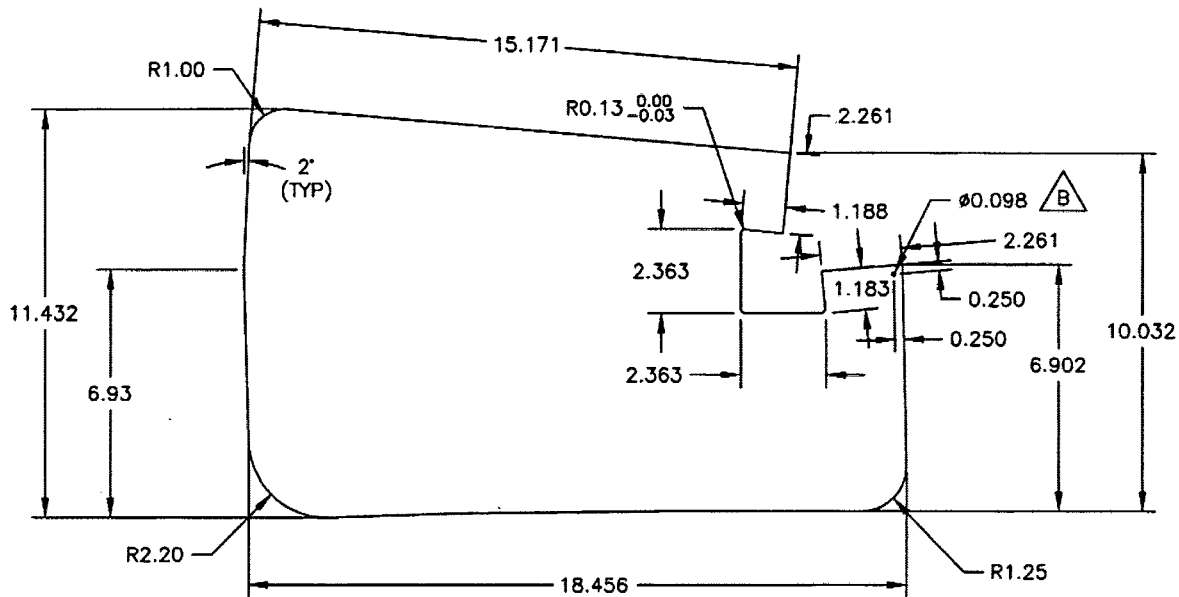
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CHECKED IP	APPROVED TF	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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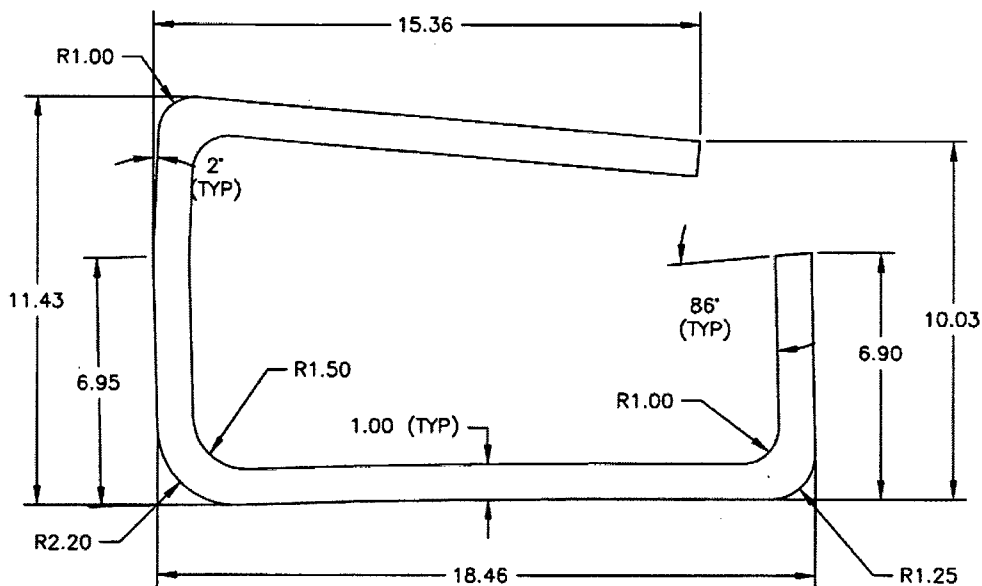
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DESIGN TJ	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LP	APPROVED TJ	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01.18 #**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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